

Date: Tuesday, 4/18/2006 9:59:03 AM
 User: Kim Johnston

Process Sheet

split

SB 06/05/19 (2)

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FOLDING STEP WELDMENT RH
 Job Number : 26653
 Estimate Number : 10697
 P.O. Number : N/A Part Number : D3388042
 This Issue : 4/18/2006 S.O. No. : N/A Drawing Number : D3388 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : A
 Previous Run : 26157 Material : N/A Due Date : 5/10/2006 Qty: ② -5 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : 06.04.18
 Comment : Est. B 05.06.10 Added Step 11 KJ/JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D2622120C

Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

D2622-120C extrusion

Batch: 324563

PE 06.04.24 5

2.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

CUT D2622-120C extrusion 85.15" long as per Dwg D3388

Deburr and bevel ends for welding

PE 06.04.24 5

3.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

206 Step Endplate

Pick:

Qty

Part Number

Description

Batch

2

D2734

End Cap

327402

PE 06.04.25 5

4.0

D33872

Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Arm

Pick:

Qty

Part Number

Description

Batch

2

D3387-2

Arm

325934 = 4326162 = 6

5

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FOLDING STEP WELDMENT RH

Job Number: 26653

Part Number: D3388042

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Weld arms and (1) end cap as per Dwg D3388.
Grind end cap welds flush
Dwg Rev: A
A/R AL ROD Batch: m19173

LE 06.04.26

LE 06.04.27

5
P10

5

6.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

DL 06/05/02

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

H.M 06/05/02

5

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Weld last end cap as per Dwg D3388.
Inspect for foreign objects as per QSI 024.
Grind end cap welds flush
Dwg Rev: A
A/R AL ROD Batch: m18838

LE 06.05.05

LE 06.05.05
FF 06.05.08

5

5

5

9.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

DL 06.05.09

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Touch up Chemical Conversion Coat as per QSI 005 4.1

DL 06/05/09

(5)

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06/05/11

(5)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FOLDING STEP WELDMENT RH

Job Number: 26653

Part Number: D3388042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3388 and QSI 005 4.4

FC 06 05 12

13.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

SB 04/05/19

14.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Spacer

Pick:

Qty Part Number Description Batch

1 D2808

Spacer

③ B26648

① 25248

Press spacer into D3387-2 arm as per Dwg D3387

SAD 06:05:19

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/05/19

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/05/19

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/05/23

Job Completion



u 06-05-23

